

Work Order ID 66469

Tuesday, February 15, 2011 11:38:45 AM



Page 1

Item ID:	D4032-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Short Basket Assembly (350)					
Start Date:	2/21/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	2/28/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>ME</u>	Date:	<u>11-02-15</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4032	D								
100	Pick Kit	0.00							
	Packaging								
	Packaging								
110	Assemble as per dwg	0.00							
	HandFinish								
	Hand Finishing								
120	QC5- Inspect part completeness to step on W/O	0.00							
	QC								
	Quality Control								

EP 4/03/02 ①

EP 11/03/03 ①

11 03 03 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66469

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Page 2

Item ID: D4032-041

Accept

Revision ID:

Item Name: Short Basket Assembly (350)

Start Date: 2/21/2011 Start Qty: 1.00

Required Date: 2/28/2011 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PP666467 0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

04/3/3 (1)

11/03/03

MF

11-03-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, February 15, 2011 11:38:39 AM

Page 1

Work Order ID: 66469

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)




Start Date: 2/21/2011

Required Date: 2/28/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.12.02 verified by:EC IPP Rev:B as per PA3 DD 10.03.10 verified by:EC IPP Rev:C as per RevA DD 10.03.23 verified by:EC IPP Rev:D as per dwg revC DD 10.04.20 verified by:EC IPP Rev:E as per dwg revD DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2530  Handle Weldment		Manufactured	No			100	Each	5.0000	1	1		EP 5/11/03/02	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST506			5						
					65094		5						
D2535  Spring		Manufactured	No			100	Each	39.0000	2	2		EP 5/11/03/02	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST504			39						
					64280		39						
D2537  Bushing		Manufactured	No			100	Each	39.0000	2	2		EP 5/11/03/02	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST504			39						
					64064		9						
					65077		30						

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 2

Work Order ID: 66469

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 2/21/2011

Required Date: 2/28/2011

Start Qty: 1.00

Required Qty: 1.00


D3917-3
Washer

Manufactured No

100 Each

14.0000

6

6



EP 54/05/03
B66906 (52)

Location

Loc Qty

Loc Code

ST095

13

65674


13

ST096

1

57144

1

D3953-3

Gas Spring Stud, Lid

Manufactured No

100 Each

15.0000

2

2



EP 54/03/02

Location

Loc Qty

Loc Code

ST096

15

65620

15

D3953-7

Spring Spacer

Manufactured No

100 Each

18.0000

2

2



EP 54/03/02

Location

Loc Qty

Loc Code

ST096


18

65053

1

65621

17

D3953-9

Gas Spring Washer

Manufactured No

100 Each

8.0000

2

2



EP 54/03/02

Location

Loc Qty

Loc Code

ST096

6

65136

6

ST103

2

60008

2

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Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 66469

Parent Item: D4032-041



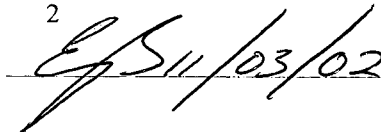
Parent Item Name: Short Basket Assembly (350)

Start Date: 2/21/2011

Required Date: 2/28/2011

Start Qty: 1.00

Required Qty: 1.00

D3953-17	Manufactured	No	100	Each	23.0000	2	2
							
Gas Spring Spacer							
						</	

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 66469

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 2/21/2011

Required Date: 2/28/2011

Start Qty: 1.00

Required Qty: 1.00

D4017-041

Manufactured No

100

Each

1.0000

1

1



Short Basket Base Assembly (350)

B66472 (K)



ES 11/03/02

Location

Loc Qty

Loc Code

GA

1

65934

1

D4018-041

Manufactured No

100

Each

0.0000

1

1



Short Basket Lid Assembly (350)

B66473 (1x)



ES 11/03/02

AN3-14A

Purchased No

100

Each

31.0000

4

4



Bolt



ES 11/03/02

Location

Loc Qty

Loc Code

ST351

31

115108

31

AN3-16A

Purchased No

100

Each

90.0000

2

2



Bolt



ES 11/03/02

Location

Loc Qty

Loc Code

ST352

90

114752

40

116419

50

AN4-12

Purchased No

100

Each

61.0000

3

3



Bolt



ES 11/03/02

Location

Loc Qty

Loc Code

ST357

61

116419

11

116786

50

3

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 66469

Parent Item: D4032-041









Parent Item Name: Short Basket Assembly (350)

Start Date: 2/21/2011

Required Date: 2/28/2011

Start Qty: 1.00

Required Qty: 1.00

AN5-17A  Bolt	Purchased	No	100	Each	116.0000	4	4		<u>4</u> EFS11/03/02
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST339	116					
			116003	16					
			116590	100					
AN310-4  NUT	Purchased	No	100	Each	49.0000	3	3		<u>3</u> EFS11/03/02
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST324	49					
			116786	49					
AN310C4  Nut	Purchased	No	100	Each	49.0000	2	2		<u>2</u> EFS11/03/02
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST324	49					
			116741	49					
MS21042L3  Nut	Purchased	No	100	Each	2,758.000	6	6		<u>2</u> EFS11/03/02
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST300	2758					
			114784	9					
			115835	249					
			116391	900					
			116540	800					
			116549	800					

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 66469

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 2/21/2011

Required Date: 2/28/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

100

Each

1,090.000

4

4



Nut



EP 5/11/03/02

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

1064

115594

368

116105

496

116548

200

4

MS24665-151

Purchased

No

100

Each

538.0000

3

3



Cotter Pin



EP 5/11/03/02

Location

Loc Qty

Loc Code

ST309

538

17566

538

3

MS24665-300

Purchased

No

100

Each

118.0000

2

2



Cotter Pin



EP 5/11/03/02

Location

Loc Qty

Loc Code

ST309

118

110123

18

116823

100

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Tuesday, February 15, 2011 11:38:40 AM

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Work Order ID: 66469

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 2/21/2011

Required Date: 2/28/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0432P Purchased

No

100

Each

336.0000

6



Washer



6
Ep 5/11/03/02

Location

Loc Qty

Loc Code

ST275

336

112940

92

114405

1

116169

1

116737

242

NAS1149C0432R Purchased

No

100

Each

220.0000

2



Washer



2
Ep 5/11/03/02

Location

Loc Qty

Loc Code

ST297

220

114292

36

116304

91

116805

93

M116900 (27)

NAS1149F0332P Purchased

No

100

Each

196.0000

8



WASHER



8
Ep 5/11/03/02

Location

Loc Qty

Loc Code

ST275

196

18057

196

NAS1149F0563P Purchased

No

100

Each

130.0000

4



Washer



4
Ep 5/11/03/02

Location

Loc Qty

Loc Code

ST298

130

114576

130

4

Tuesday, February 15, 2011 11:38:40 AM

Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

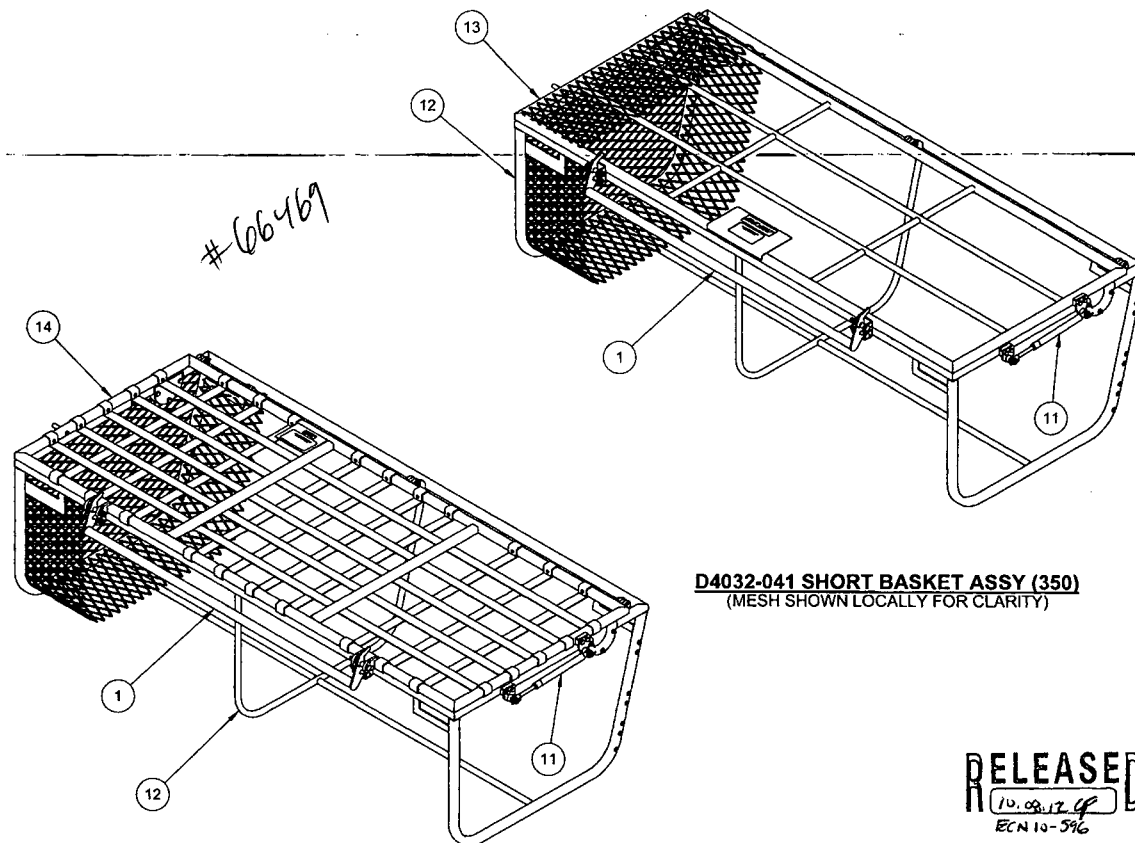
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NOTE: Date & initial all entries

ITEM	-041 QTY.	-043 QTY.	P/N	DESCRIPTION
	X		D4032-041	SHORT BASKET ASSY (350)
		X	D4032-043	SHORT BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	6	6	D3917-3	WASHER
5	2	2	D3953-3	GAS SPRING STUD, LID
6	2	2	D3953-7	GAS SPRING SPACER
7	2	2	D3953-9	GAS SPRING WASHER
8	2	2	D3953-17	GAS SPRING SPACER
9	1	1	D3953-19	GAS SPRING BRACKET
10	1	1	D3953-21	GAS SPRING BRACKET
11	1	1	D3969-3	SPRING
12	1	1	D4017-041	SHORT BASKET BASE ASSY (350)
13	1		D4018-041	SHORT BASKET LID ASSY (350)
14		1	D4019-041	LIGHT LID SHORT BASKET ASSY
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	2	2	NAS1149C0432R	WASHER
29	8	8	NAS1149F0332P	WASHER
30	4	4	NAS1149F0563P	WASHER



D4032-041 SHORT BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

D4032-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.09.12
ECN 10-596

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: -041: 56 lbs APPROX
-043: 45 lbs APPROX

D	QTY FOR ITEMS #28, #29 & #30 UNDER -043 WERE MISSING (B8-1); QTY FOR ITEM #3 WAS 4 (D6-1), ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3).	MB	10.07.23
C	AN5-21A BOLT WAS AN5-19A BOLT: BOM & (D3-3)	JPH	10.04.08
B	ITEM 15 D4086-232 & 16 D4086-243 REMOVED, ITEM RENUMBERED AS REQD. PLACARDS REMOVED (C6-2); TOP VIEW DETAIL REMOVED (C2-2)	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.08
REV.	DESCRIPTION	BY	DATE
DESIGN	145		
DRAWN	145		
CHECKED	145		
MFG. APPR.	145		
APPROVED	145		
DE APPR.	145		
DATE	10.07.23		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4032** REV. D
SHEET 1 OF 3

TITLE **SHORT BASKET ASSY (350)** SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

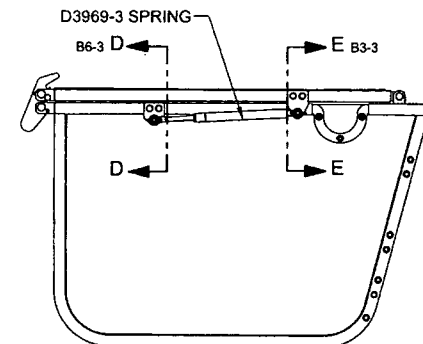
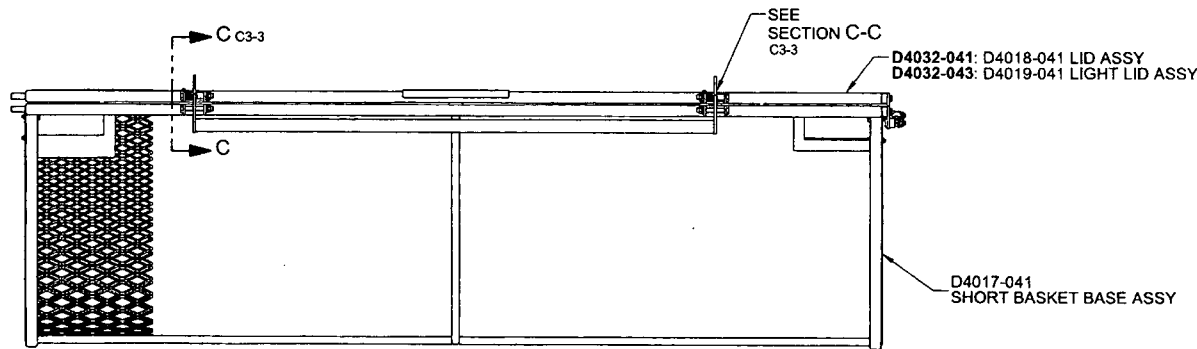
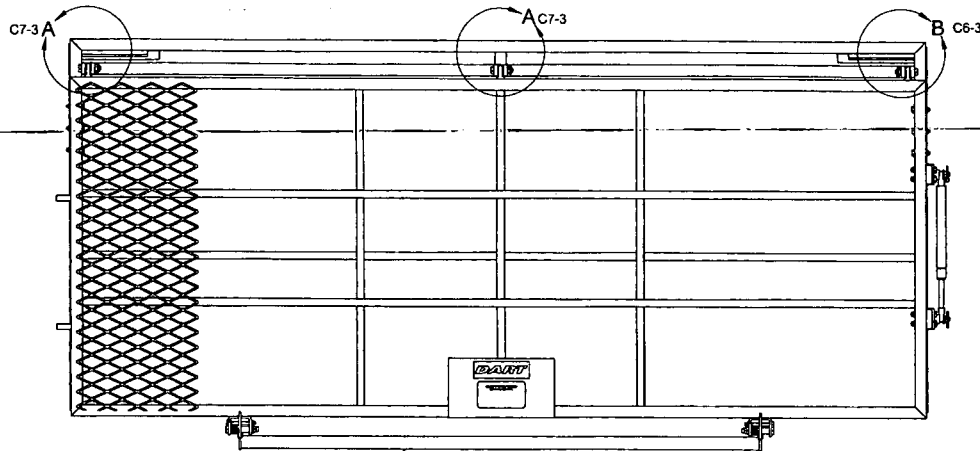
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D4032-041 SHORT BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)
D4032-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.12

DESIGN	AIS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4032	REV. D
MFG. APPR.	J.F.S.	SHEET 2 OF 3	
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET ASSY (350)	NTS
DATE	10.07.23	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

Dart Aerospace Ltd

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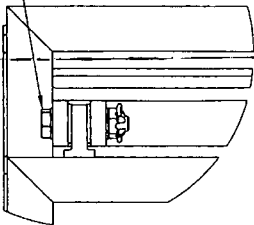
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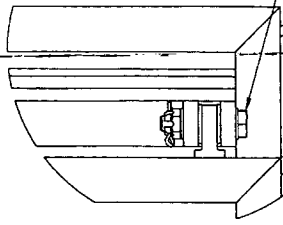
NOTE: Date & initial all entries

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



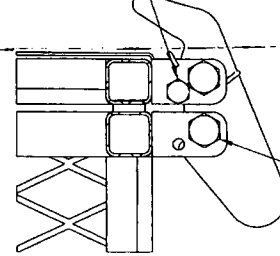
DETAIL A D8-2
D6-2

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



DETAIL B D4-2

D4032-041: AN3-16A BOLT
MS21042L3 NUT
D4032-043: AN3-20A BOLT
MS21042L3 NUT

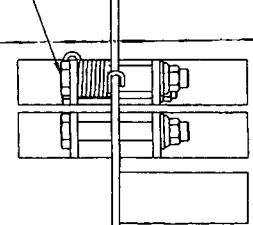


SECTION C-C B5-2
B7-2

D4032-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

D4032-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

AN5-17A BOLT
NAS1149F0563P WASHER
MS21042L5 NUT



VIEW F-F C3-3

D2530 WELDMENT
REF

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET

AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-2

D3953-17 GAS SPRING SPACER

D3953-19 GAS SPRING BRACKET

AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-2

RELEASED
10-08-17-0

DESIGN	AKS	DART AEROSPACE LTD	
DRAWN	AKS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AKS	DRAWING NO. D4032	REV. D
MFG. APPR.	AKS		SHEET 3 OF 3
APPROVED	AKS	TITLE SHORT BASKET ASSY (350)	SCALE NTS
DE APPR.	AKS		
DATE	10.07.23		

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries